

Work Order ID 150099 - 1 split

150099

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Wednesday, August 24, 2016 11:31:11 AM

Item ID: D3859-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 8/19/2016 Start Qty: 12.00 *12* 8 dm Cust Item ID:
 Required Date: 8/24/2016 Req'd Qty: 12.00 *12* 8 dm Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: AUG 24 2016 Tooling: Date: Run Start *NR1*
 QC: 9-89 Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3859	B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.42							
FLOW CNC Waterjet	1-Cut as per Dwg D3859-1 Dwg Rev: 5 Prog Rev: 6 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.02							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.04							
Quality Control									

AUG 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Required Date: 8/24/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab	Weld per dwg A/R S.S. rod Batch: <u>123823</u> Large Fab	0.00				9			16-09-15 JRL
Large Fab	Memo 1-Weld D4379-5 cups as per dwg D3859 A/R 316L stainless steel rod *****use DT9462 for welding***** 1- WELD HARDCOAT TO BAR 130145 2059B HARDCOAT BATCH: <u>130145</u>	1.08							
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				9	16-09-20		DAS 9 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				9	16-09-20		DAS 9 9-89

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Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval
Description Work Order Deviation				Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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180	Identify as per dwg & Stock Location: <u>St</u>	0.00				DAS 6 9-89		SEP 22 2016	
180	Packaging	Memo							
Packaging		0.02							
190	QC21- Final Inspection - Work Order Release	0.00							
190	QC	Memo					DAS 21 9-89	SEP 22 2016	
Quality Control		0.20							
							DAS 21 9-89	SEP 22 2016	

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Work Order update only ☐

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Picklist Print

Wednesday, August 24, 2016 11:31:15 AM

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Work Order ID: 150099

150099

Parent Item: D3859-041

D3859-041

Parent Item Name: Wearplate Assembly

Start Date: 8/19/2016

Required Date: 8/24/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC
14.04.30 as per dwg rev.b DD verified by:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4379-5		Manufactured	No			130	Each	28.0000	6	72			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D4379-5

Wearplate Cup

16-09-15
JBL

Location

Loc Qty

Loc Code

WA001

150247

28

need 44

141320

8

148173

20

44
20

M304S16GA

Purchased

No

100

sf

126.2698

0.85

10.2

2016/09/28

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT010

109.77

m134677

4.27

m135061

2.2

m135377

103.3

TPI

16.499794

m134604

16.499794

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

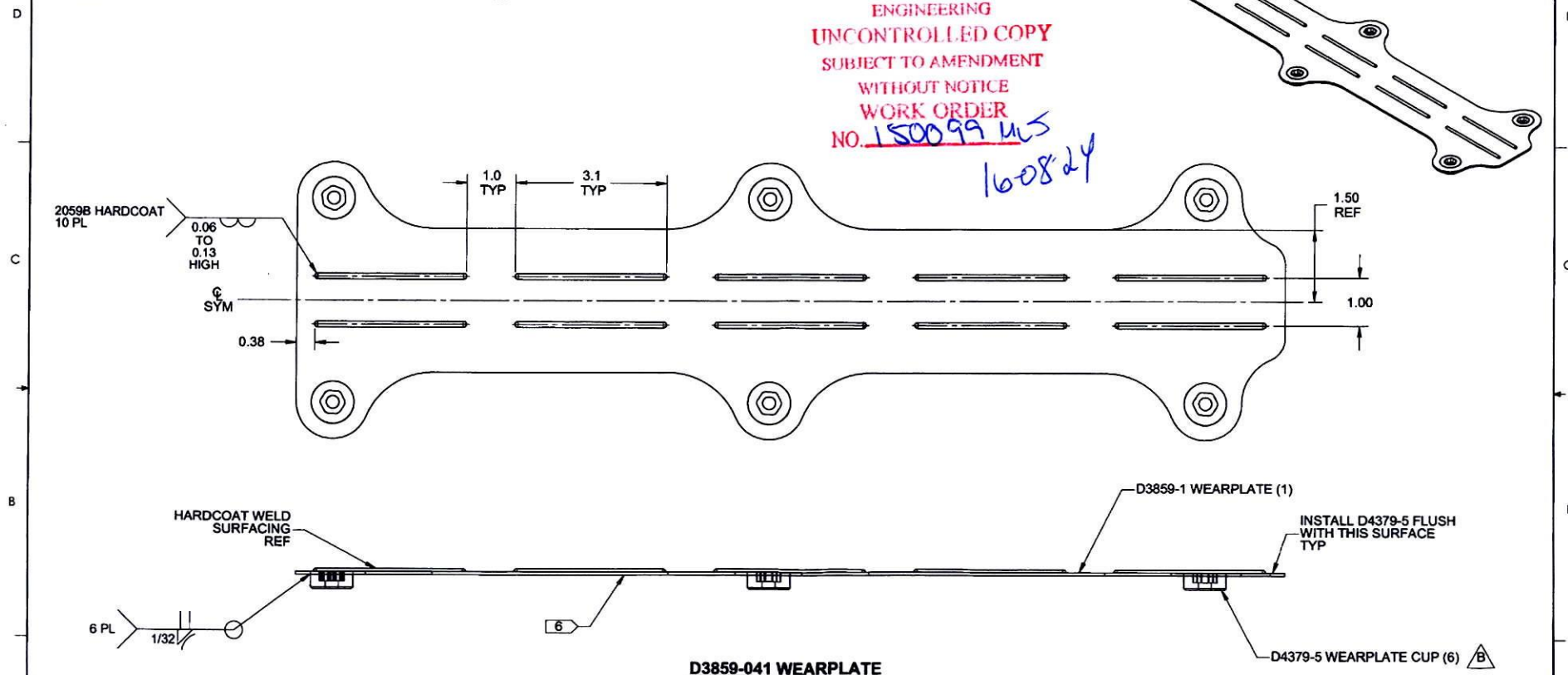
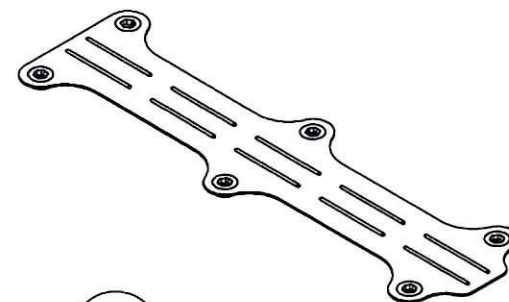
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ITEM NO.	QTY.	P/N	DESCRIPTION
	X	D3859-041	WEARPLATE
1	1	D3859-1	WEARPLATE
2	6	D4379-5	WEARPLATE CUP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150099 *WLS*
160824



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.58 lbs
 - 8) WELD PER DART QSI 004

RELEASED
2014 MAR 29
ECN 14-544

APPROVED

B	D4379-5 CUP WAS D3009-3 CUP	DB	14.03.05
A	NEW ISSUE	HS	09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS		
DATE	14.03.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3859	REV. B SHEET 1 OF 2
TITLE WEARPLATE	SCALE NTS
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